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(21) Application number: **11311933**(22) Date of filing: **02.11.99**(71) Applicant: **SEIKO INSTRUMENTS INC**

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(54) **METHOD OF ASSEMBLING SHAFT WITH
 FLANGE AND FLUID DYNAMIC PRESSURE
 BEARING**

(57) Abstract:

PROBLEM TO BE SOLVED: To assemble a shaft with flange by press fitting a ring member into a cylindrical member with accurate perpendicularity, to improve stability in high-speed rotation of a fluid dynamic pressure bearing basically composed of the shaft with flange and a sleeve receiving the same, and to realize the long service life.

SOLUTION: This method of assembling a shaft 1 with flange comprises (A) a stage for inserting and setting a cylindrical member 2, having a cylindrical part 2b and a tapered cylindrical part 2a of a very small inclination angle having a diameter reduced continuously from the cylindrical part 2b to one end part, into a guide jig 6 having a tapered cylindrical part 6a of very small inclination angle same as that of the tapered cylindrical part 2a, and (B) a stage for press fitting a ring member 3 to the cylindrical member 2 to a prescribed position of the

cylindrical part 2b. Finally, the guide jig 6 is taken out of the cylindrical member 2 to complete the assembling of the shaft 1 with a flange.

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